

Work Order ID 60410

July 7, 2010 10:07:06 AM

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Item ID: D3975-042

Revision ID: 8

Item Name: Gas Cylinder Assembly, RH

Start Date: 7/07/10

Start Qty: 5.00

Required Date: 7/08/10

Req'd Qty: 5.00

Reference:

Approvals:

Process Plan: W

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3975

B

110



Small Fab

Small Fab

Memo

Pull from stock: D3975-1
8 x 41232-200-007-001 B
re-identify as D3975-042
change decal to D39763
apply decal as per dwg

0.00

0.00

80 10/07/07

0.00

0.00

5 dots 107

120



QC

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

80

Accept



Setup

Start

Stop

Cust Item ID:

Customer:



Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

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Item ID: D3975-042

Revision ID:

Item Name: Gas Cylinder Assembly, RH

Start Date: 7/07/10 Start Qty: 5.00

Required Date: 7/08/10 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: ST 367 0.00

Set Up/
Run Hours

Memo

re-stock under D3975-042
using new B/N

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

MF
10-7-7

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF
10-7-7

Picklist Print

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Work Order ID: 60410

Parent Item: D3975-042

Parent Item Name: Gas Cylinder Assembly, RH

Page 1

Start Date: 7/07/10

Start Qty: 5.00

Required Date: 7/08/10

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC
10.05.27 as per ECN10-548 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty
41232-200-007-001 Brass Cylinder Assembly		Purchased	No				Each	9.0000		5

Location

ST365
39219
42266
43733

Loc Qty

9 B58 015
1
4
4

Loc Code

110 Each 10.0000

D3976-3



Decal

Manufactured No

Location

ST139
52630

Loc Qty

10
10

Loc Code


Qty
Issued

Date
Issued

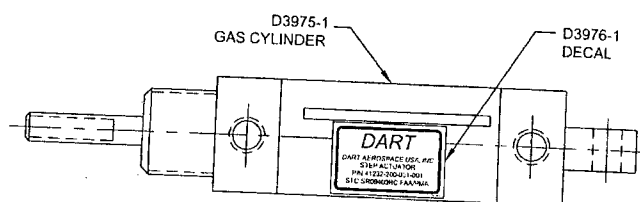
Status

8/11/07/07

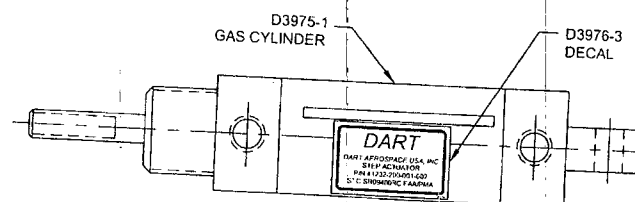
8/10/07/07

ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 	DECAL

94 41232-002 - 007.001



D3975-041 GAS CYLINDER ASSEMBLY



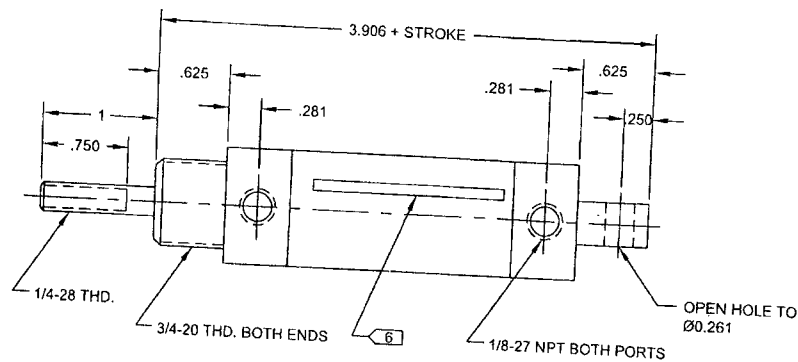
D3975-042 GAS CYLINDER ASSEMBLY

RELEASED
2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1).	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3975	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC	

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60409 / 60410



D3975-1 BRASS CYLINDER

NOTES:

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 8) BORE: 0.875 INCHES
- 9) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

WFO 6040

RELEASED
R 2010-05-20

DESIGN	AS	DART AEROSPACE USA, INC	
DRAWN	[Signature]	PORT HADLOCK, WA	
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D3975	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	GAS CYLINDER ASSEMBLY	NTS
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